

Work Order ID 127852

127852

Page 1

Item ID: D2965

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cap

Stop

NS2

Start Date: 12/17/14

Start Qty: ~~30.00~~ ¹⁰⁰

~~*30*~~ ^{100 Q/L 15/01/12}

Cust Item ID:

Required Date: 12/17/14

Req'd Qty: ~~30.00~~

~~*30*~~

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: 14-12-23

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 27002

Cast per Dwg D2965

Supplier: Metallurgie Syca

Material Release Note Required

Q/L 15/01/12 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

105x Sp 15-02-11

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

(105)

DAS
38
9-89

FEB 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Work Order ID 127852

127852

December-17-14 1:57:31 PM

Page 2

Item ID: D2965 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 12/17/14 Start Qty: 30.00 ***30*** 105x
 Required Date: 12/17/14 Req'd Qty: 30.00 ***30***
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Drill as per Dwg D2965 with DT8538Deburr and Tumble								
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Powdercoat	0.00							
150									
Powdercoat	Memo M129808.	0.00							
Powder Coating	Mask as per Dwg D2965 Powder To match Skidtube (Ref: 4.3.5.x) as per QSI								
	005 4.3 START TIME: 3:20 OVEN TEMPERATURE:								
	3:20 FINISH TIME: 3:50								

105x
 DAS 28 9-89
 FEB 17 2015
 105
 DAS 38 9-89
 FEB 18 2015
 105 \$ 15-2-19
 DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Page 3

105 ϕ 15-2-23. DAS 34 9-89

DQA: _____ Date: _____



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Transport									
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Work Order ID 127852

December-17-14 1:57:31 PM

127852

Page 4

Item ID: D2965 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 12/17/14 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-001</u> Memo	0.00 0.00				<u>X105</u>	<u>q</u>	<u>15/02/23</u>	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>15/2/23</u>	

15.2-23

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

December-17-14 1:57:30 PM

Page 1

Work Order ID: 127852

127852

Parent Item: D2965

D2965

Parent Item Name: Cap

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: A00.05.31New Issue EC

IPP Rev:Added Turning as per Rev B 06-12-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	120.0000	2	210			
AI S7-1032-225									**				
Insert													

Location

Loc Qty

Loc Code

FG

120

118520

120

D2965P

Purchased

No

170

Each

0.0000

1

D2965P

Cap

**

30

105x 8015-02-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

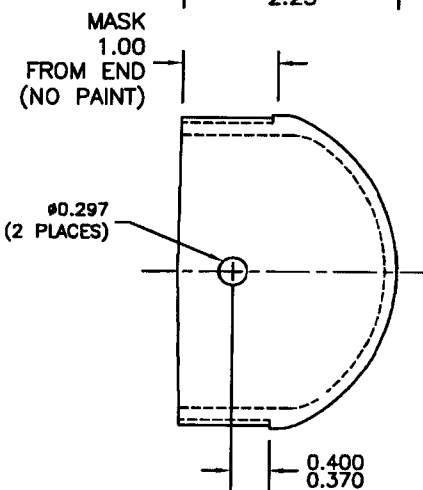
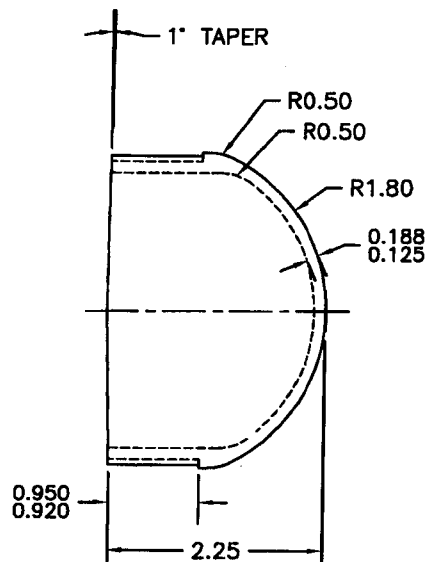
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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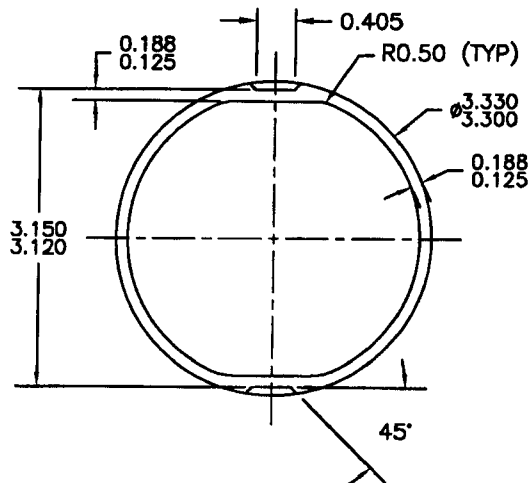


RELEASED
06.12.12

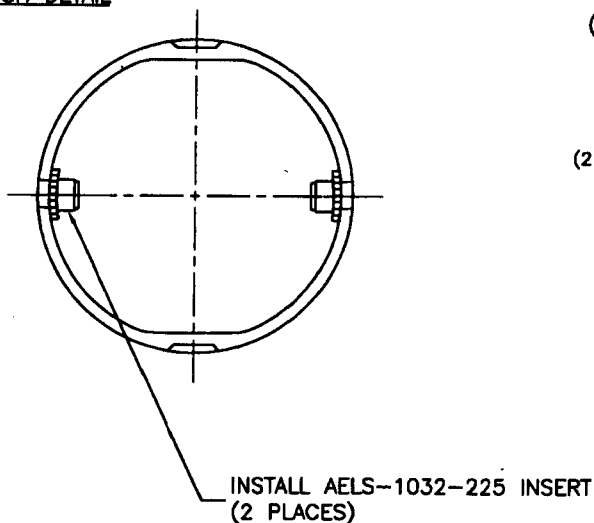
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
014	014	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
		D2965	
DATE	TITLE	SCALE	
06.11.01	CAP	1:2	
A	00.02.24	NEW ISSUE	
B	06.11.01	ADD -3 CAP	



D2965 CASTING DETAIL



D2965 FINISH DETAIL



D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

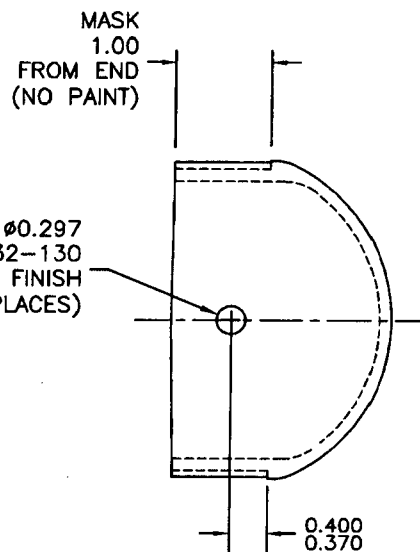
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH WORK ORDER
NO. 123-852 MWS
14-12-23



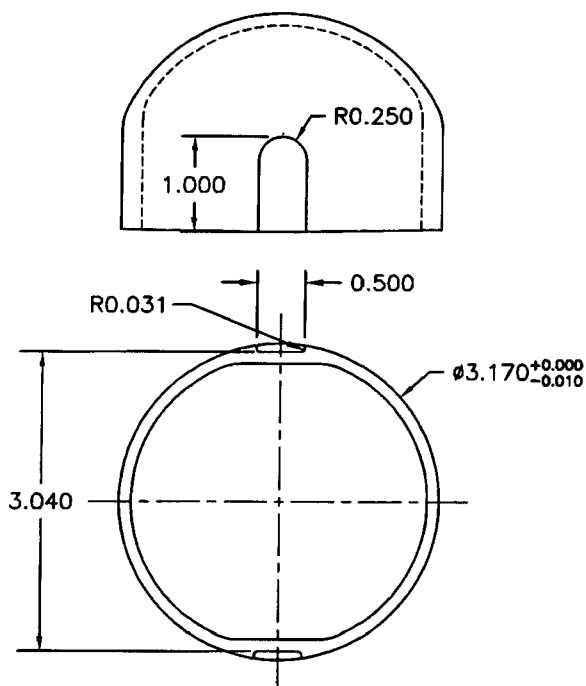
RELEASED

06.12.12

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.11.01	TITLE	CAP	REV. B
				SHEET 2 OF 2
				SCALE 1:2



D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27002

Purchase Order Date 1/12/2015

PO Print Date 1/12/2015

Page Number 1 of 2

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

METALLURGIE SYCA
500 PRINCIPALE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST.DOMINIQUE, QUEBEC JOH 1LO

Contact Name

Vendor Phone 450-261-0853

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Overnight collect

FOB

EXW - (Ex Works)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B B127359	Cap	1/30/2015 Yes 1/30/2015		50.00 Each	\$12.50	\$625.00
Line Total:							\$625.00
2	D2855P AS PER DWG D2855 REV. B B127596	Cap	1/30/2015 Yes 1/30/2015		50.00 Each	\$12.50	\$625.00
Line Total:							\$625.00
3	D2965P AS PER DWG D2965 REV. B B127852	Cap	1/30/2015 Yes 1/30/2015		100.00 ✓ Each	\$12.50	\$1,250.00

SP15-02-11

PO Instructions: Fedex Acc#151793240

Note:

1/12/2015

MÉTALLURGIE SYCAM
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

VENDU À
SOLD TO

ADRESSE
ADDRESS

EXPÉDIE À
SHIP TO

ADRESSE
ADDRESS

P027002

DATE 10-02-2015

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKSBURY ONT.

K6A-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

105

D-2965

1 BOX X 80 PCS X 32 LBS

1 BOX X 25 PCS X 10 LBS

SP1502

TRANSPORT FEDEX

THANK FOR YOUR SUPPORT

TOTAL

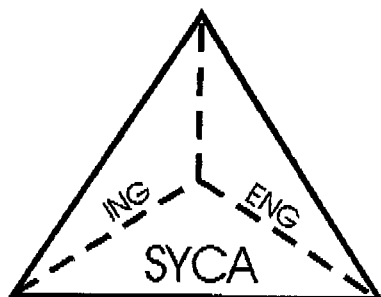
551553

Blueline DCB27

SIGNATURE

FORMULAIRE DE VENTE - SALES ORDER

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**MÉTALLURGIE SYCA Inc.**

500, Principale
St-Dominique, Québec
J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

W W W . S Y C A - I N C . C O M

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2015-FEB-12

SHIPPING MEMO: 551553

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2965	105	D-2965	27002

All item specify in this compliance certificate are manufactured in Canada.

-**PRODUCTION LOT:** KJJ21022015

-**ALLOY:** A-356

-**NORME:** ASTM B-85

-**CHEMICAL ANALYSIS:** SUPPLY

-**VISUAL INSPECTION:** DONE

-**DIMENSIONNAL INSPECTION:** NON-APPLICABLE

-**SURFACE SMOOTHNESS :** ALUMINIUM ASSOCIATION DATA

SA-101

RESPONSIBLE: CARL JOBIN ING.